

DART AEROSPACE LTD	Work Order:	22740
Description: D2306 rework as a D2304	Part Number:	02304
Dwg:	Qty:	1
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	dkf	05.04.22	1
2	QC	Rework D2306 B# 4277 from stores	AB	05.03.15	1
3	GA	Rework D2317 / D2342 from D2306	AB	05.03.16	1
4a	GA	Rework D2303 as per Dwg D2319	AB	05.03.16	1
5	GA	Rework D2302 as per Dwg D2313	AB	05.03.16	1
6	QCS	Inspect level 5	TT	05.04.18	1
7	FP	Repowder (Cat) as per CSD1005	AB	05.04.18	1
8	QC3	Inspect level 3	u	05.04.21	1
9	ST	Ident, Sg and stock as D2304 B# 22740	u	05.04.21	1
4b	GA	Install rivet <sup>QTY</sup> DMS 200126 A04-21 H#1021	AB	05.03.16	1
10	AC	Close C code 393.35	54C	05.04.22	1
10	DC	Close w/o inspect level 21	dkf	05.04.22	1

Rev	Date	Change	Revised By	Approved
A		New issue		

IPP- Batch No: 4277

DESCRIPTION: 204 Aspirator  
Assembly

Part No: D2306

Qty: 65

Step	Location	Procedure	By	Date
1	EXPEDITING	Issue W/O		
2	STORES	CITY: D2302 D2303 D2293 D2373-4-16-163 D2301 D2294 D2281-1 D2317 D2334 D2342 D2307-1 AN3-3A AN4603D10 MS20600AD4W5 MS20600AD4W6 MS20470AD4-5 MS21042L3 NAS 1329A3K80	BATCH #: B3864 B3850 B3840 M810 M2312 B3839 B3847 B3847 B3852 B3841 B3849 4255 R1545 & M1698 R1484 MCL400 M20271 R1502 M2405	RCB 96/04/12
	METAL	ASSEMBLED AS PER D2306	CDW	96/04/12
Q.C.	INSPECT		CDW	96/04/12
STORES	BAG & TAG		RCB	96/05/24
EXPEDITING	CLOSE W/O		RCB	96/05/24

Dng D2306 incl.

75.20

## MANUFACTURER RELEASE CERTIFICATION

The aeronautical product described herein conforms to approved type design data and is in a condition for safe operation.

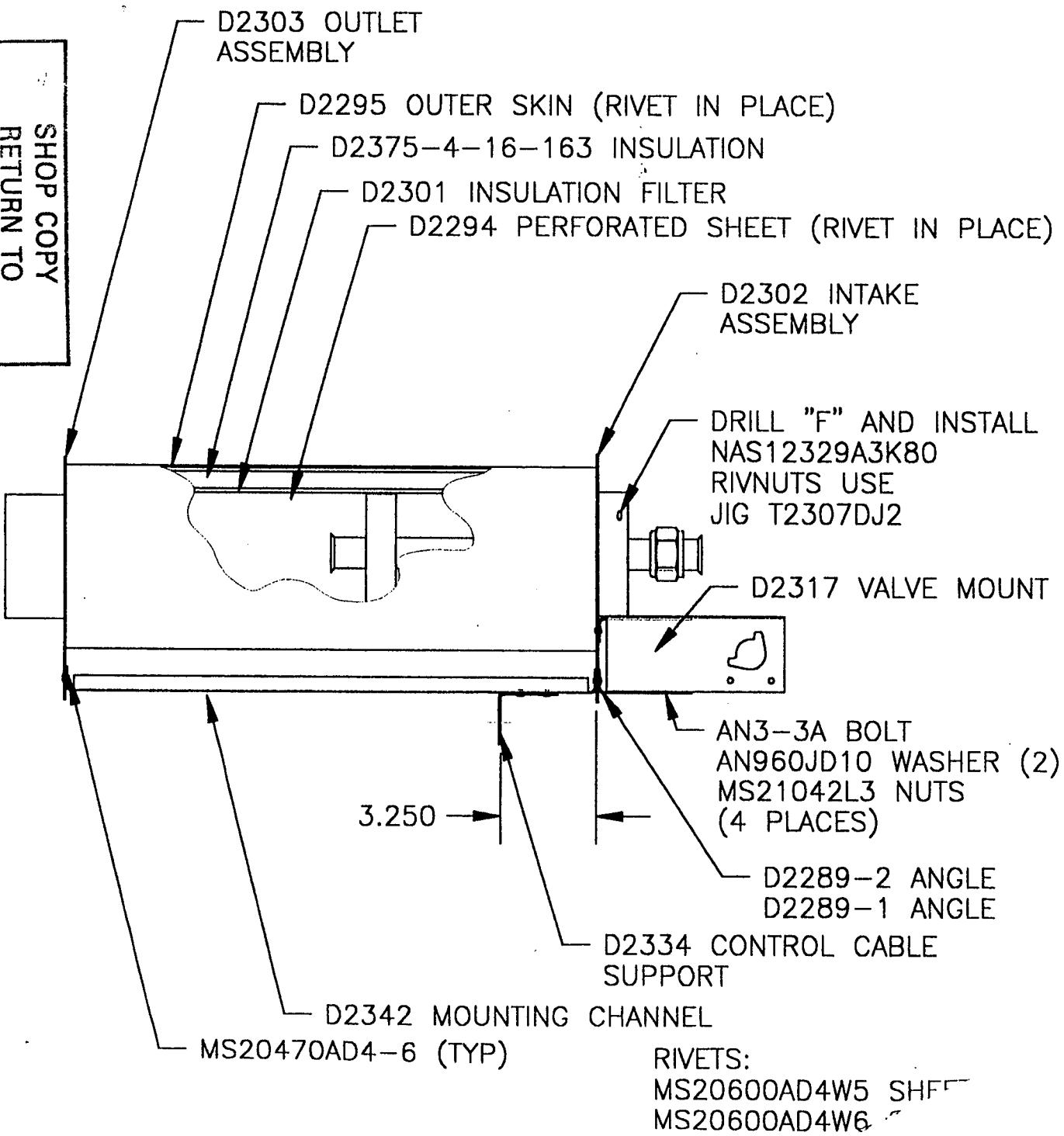
Authorized Inspector

D.O.T Approval 9-89

Date

96/05/30

SHOP COPY  
RETURN TO  
ENGINEERING



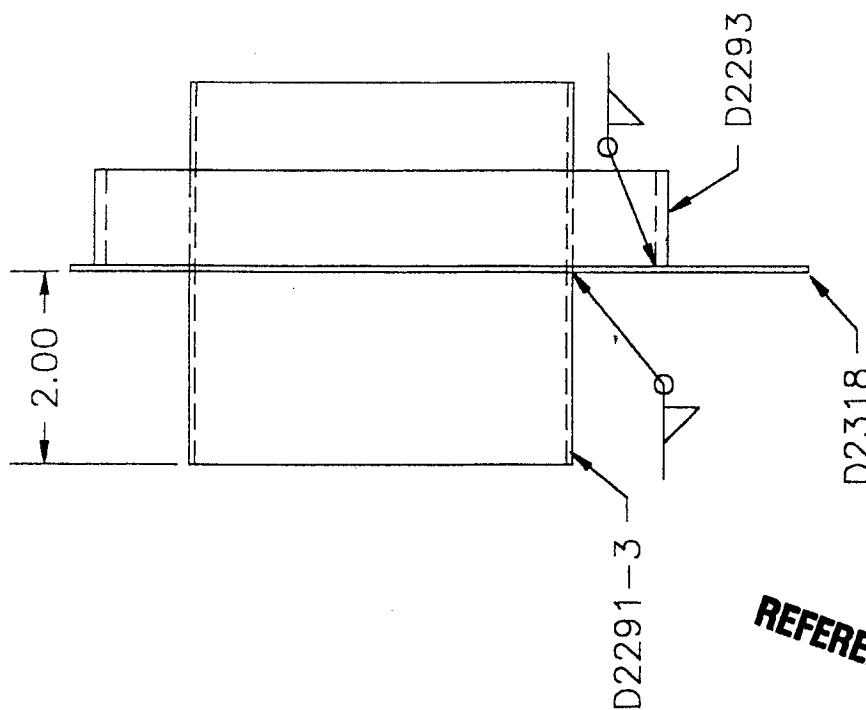
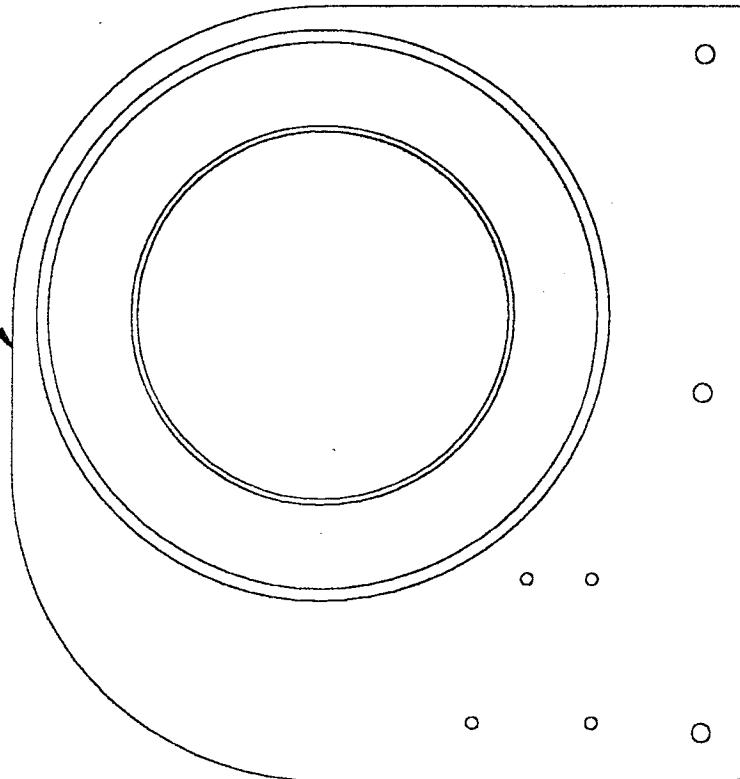
DATE 95.01.03  
TIME  
B204 ASPIRATOR ASSEMBLY

## CONTROLLED COPY

COPY ISSUE  
GENSUS

DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	DRAWING NO. D2303	REV. C SHEET 2 OF 2
DATE 94.11.02		TITLE OUTLET WELDMENT ASSEMBLY	SCALE

D2318



FINISH: ANODIZE

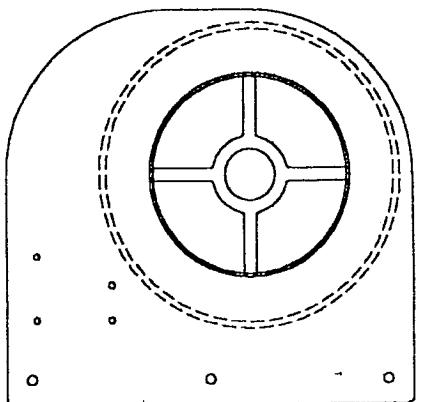
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6A COPY  
C/C

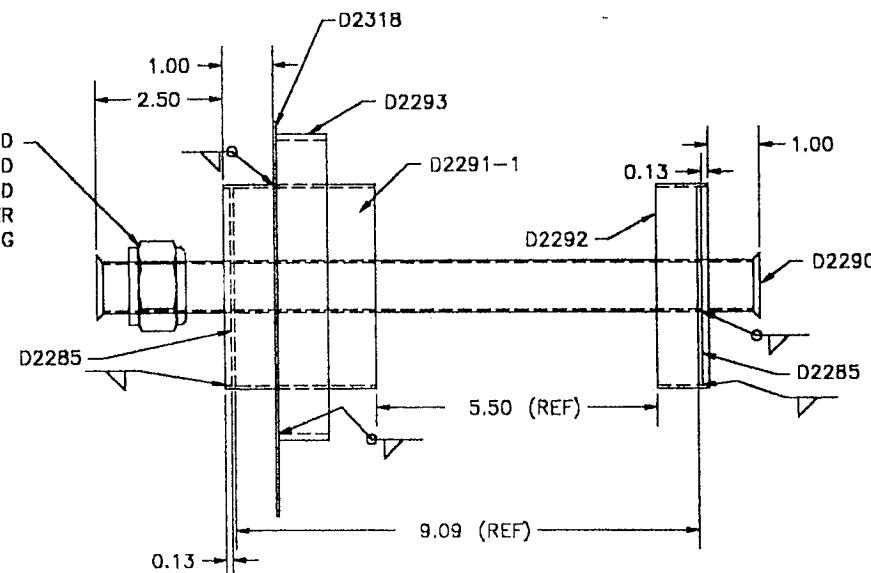
**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD
B WILLIAMS	B WILLIAMS	VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	APPROVED	REV. E
Bl	Bl	D2302
DATE	TITLE	SHEET 2 OF 2
94.10.25	INTAKE WELDMENT ASSEMBLY	SCALE

REFERENCE ONLY



AN818-16D  
MS20819-16D  
INSTALL AND  
FLARE AFTER  
ANODIZING

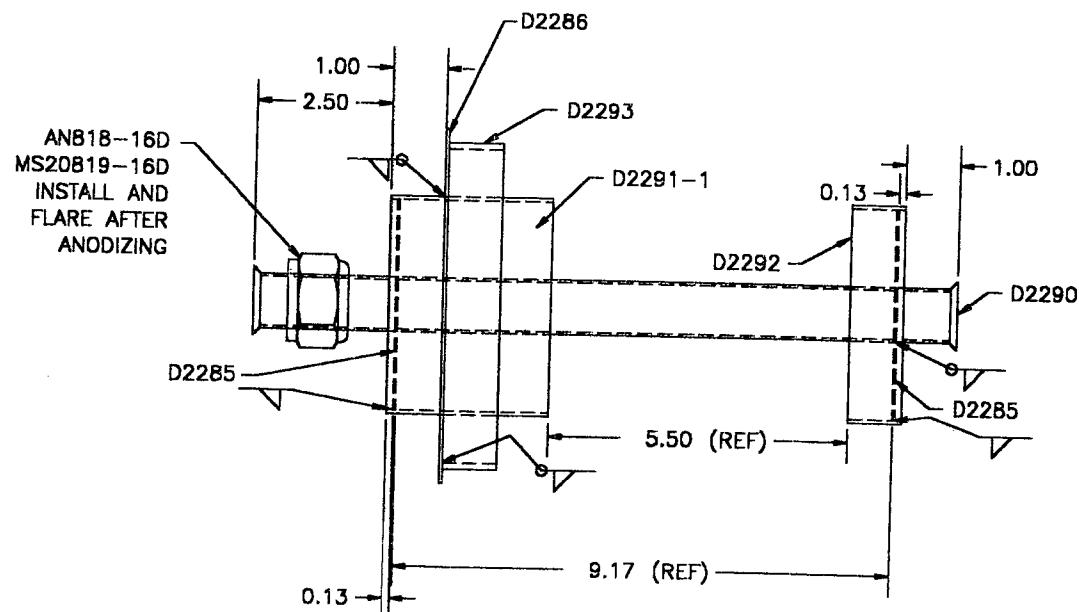
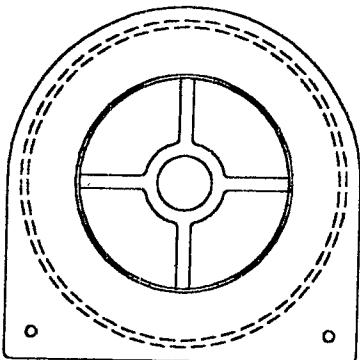


FINISH: ANODIZE



PREPARED		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
B. Williams		REV. D	
CHECKED	APPROVED	SHEET 1 OF 2	
DATE		TITLE	
Jan. 10, 1995		INLET WELDMENT ASSEMBLY	
D	96:04:18	SCALE	
MODIFIED MASTER PARTS LIST			

QTY	Part No.	Description
X	D2313	INTAKE WELDMENT ASSEMBLY
2	D2285	LOCATOR CROSS
1	D2289	END PLATE
1	D2290	JET PIPE
1	D2291-1	4" RING
1	D2292	4" RING
1	D2293	6" RING
1	AN818-16D	FLARE NUT
1	MS20819-16D	SLEEVE



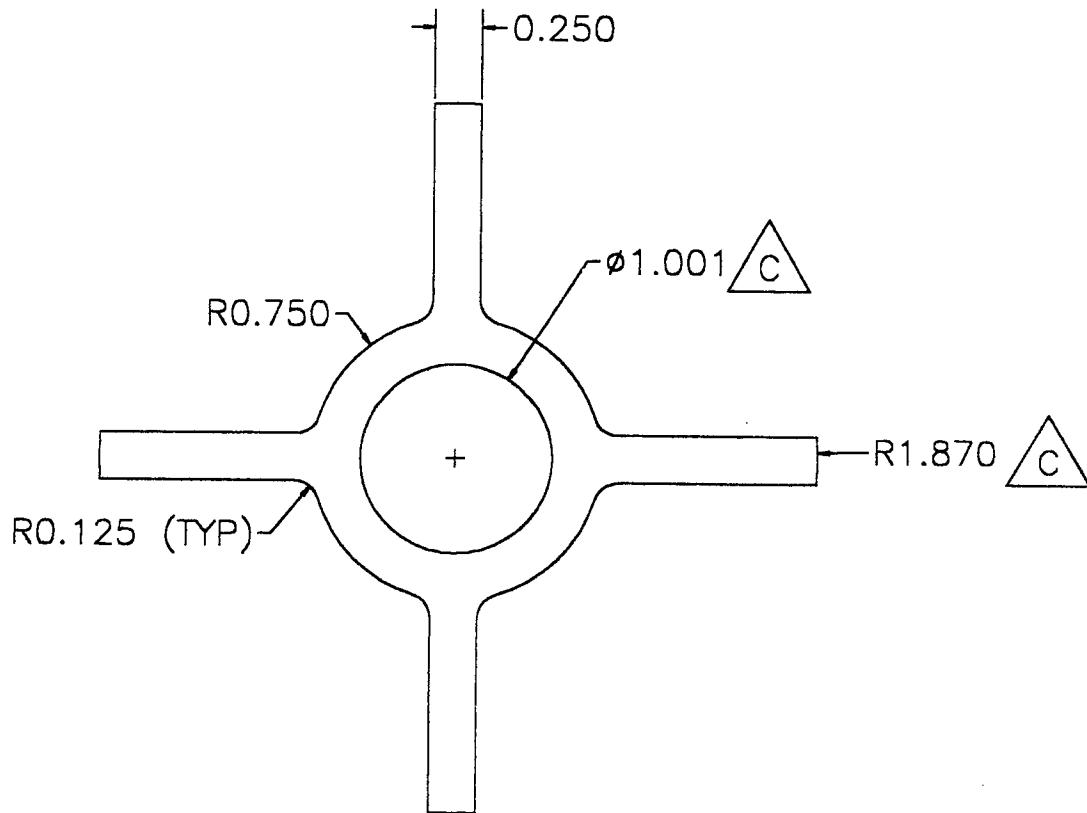
**DART**  
**AERO**

ISSUED  
3  
JULY 1995

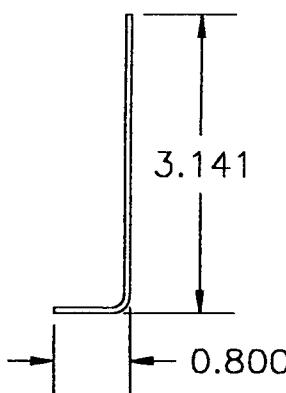
PREPARED	DART AERO ACCESSORIES INC	
B. Williams	APPROVED	D2313
CHECKED	REV. D	
DATE	SHEET 2 OF 2	
Jan. 10, 1995	SCALE	
	TITLE	INLET WELDMENT ASSEMBLY

**DART**DRAFTED  
ISSUED  
04

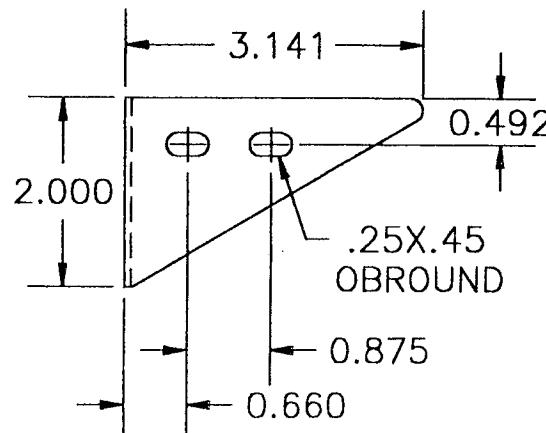
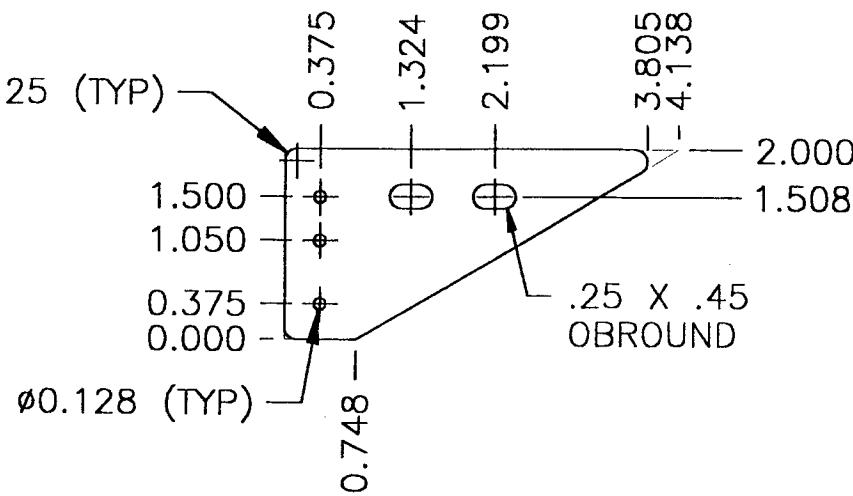
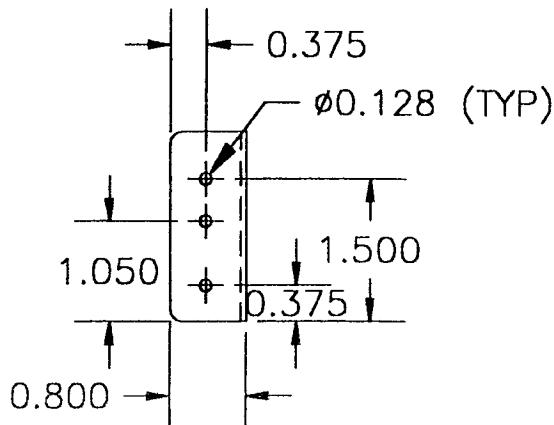
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CHECKED Bul	APPROVED Bul	DRAWING NO. D2285	REV. C SHEET 1 OF 1
DATE 94.21.21		TITLE HEATER TUBE LOCATOR	SCALE 1:1
B	Nov. 7, 1994	CHANGED ARM ENDS	
C	96.01.15	CHANGED DIMENSIONS	



MATERIAL: 5052-H34 0.080 THICK



D2289-1 SHOWN  
D2289-2 OPPOSITE



BEND RADIUS: 0.125  
MATERIAL: 5052-H34 0.063 THICK

**DART**

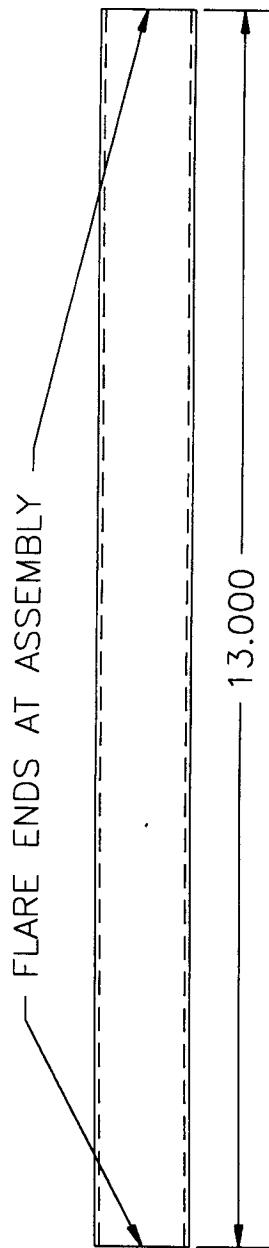
QA  
COPY  
DEC 1994

DESIGN	DRAWN BY	DART AEROSPACE LTD
B. WILLIAMS	B. WILLIAMS	VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	APPROVED	DRAWING NO.
B	R	D2289
DATE	REV. C	SHEET 1 OF 1
94.12.21		SCALE
C	96.01.15	1:2
		VALVE MOUNTING BRACKET
		CORRECTED FLAT PATTERN



CA COPY  
CENSUS

PREPARED	DART AERO ACCESSORIES INC	
B. Williams	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	REV. A
	D2290	SHEET 1 OF 1
DATE	TITLE	
Oct. 25, 1994	1" HEATER TUBE	



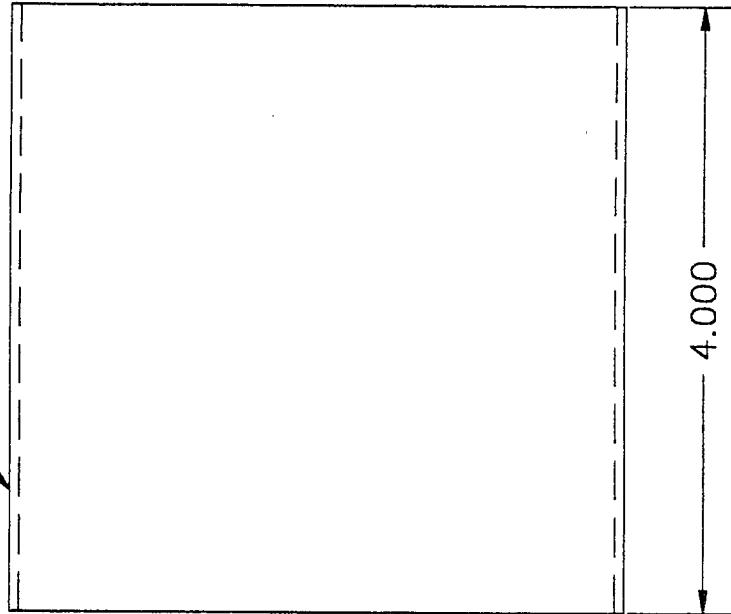
12'  
~~12.50/ft.~~  
195/ft.

MATERIAL: 6061-T6 SEAMLESS TUBE  
1" DIAM 0.049 WALL CUT 13" LONG

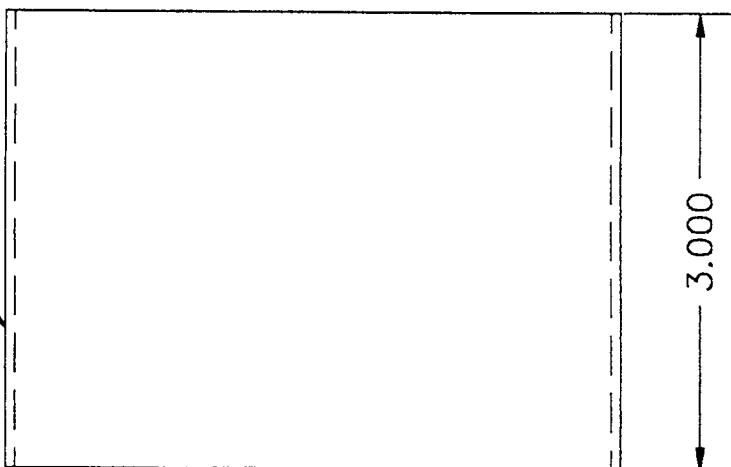
**DART**QA COPY  
CENSUS

DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED B.W.	APPROVED B.W.	DRAWING NO. D2291	REV. B SHEET 1 OF 1
DATE 94.10.25		TITLE 4" HEATER TUBES	SCALE
B	96.01.15	CHANGED MATERIAL	

D2291-3



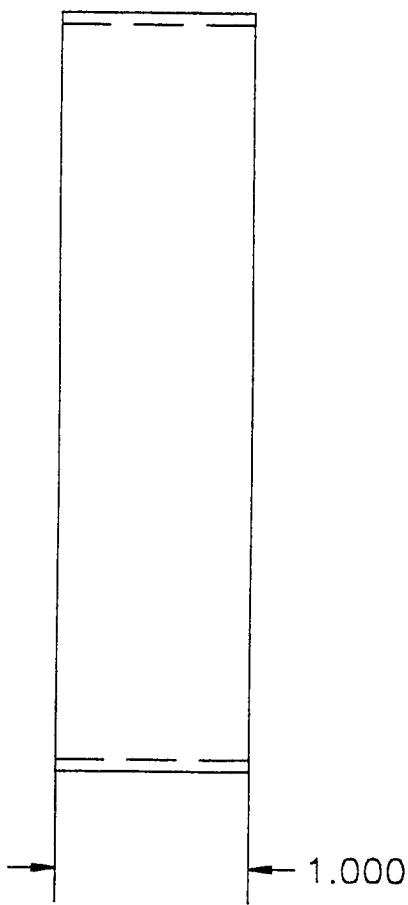
D2291-1



MATERIAL: 6061-T6 TUBE  
4" OD X 0.125 WALL



DESIGN B. WILLIAMS	DRAWN BY B. WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED B.W.	APPROVED B.W.	DRAWING NO. D2292	REV. B SHEET 1 OF 1
DATE 94.10.25		TITLE 4" HEATER TUBE	SCALE 1:1
	B	96.01.15	MATERIAL WAS 0.063 WALL

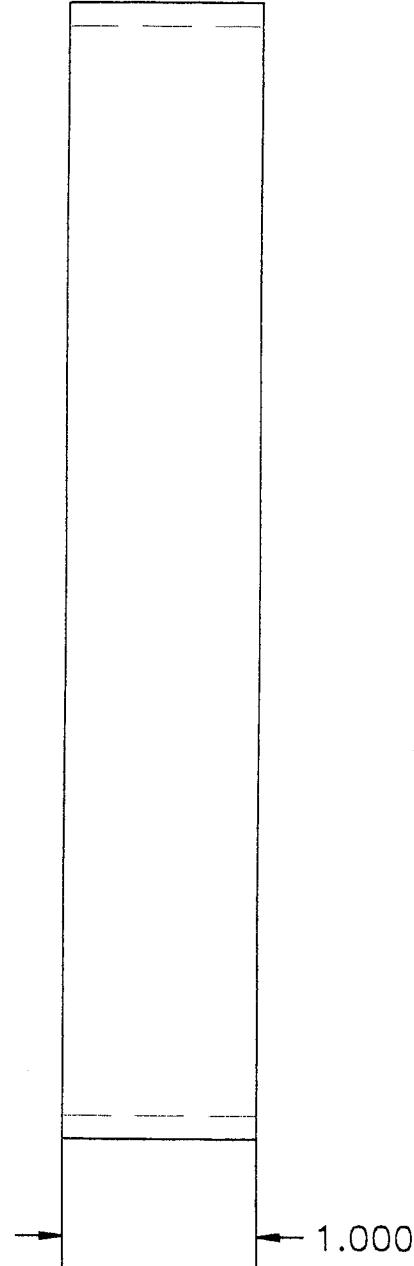


MATERIAL: 6061-T6 TUBE  
4" OD X 0.125 WALL CUT 1" LONG



QA COPY  
GENSIS

DESIGN B. WILLIAMS	DRAWN BY B. WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2293	REV. B SHEET 1 OF 1
DATE 94.10.25		TITLE 6" HEATER TUBE	SCALE 1:1
B	96.01.15	CHANGED MATERIAL	



12' = 17.61 ft 23 wks  
24' = 12.92 ft 1-2 wks

MATERIAL: 6061-T6 TUBE  
6" DIAM 0.125 WALL CUT 1" LONG



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ISSUED

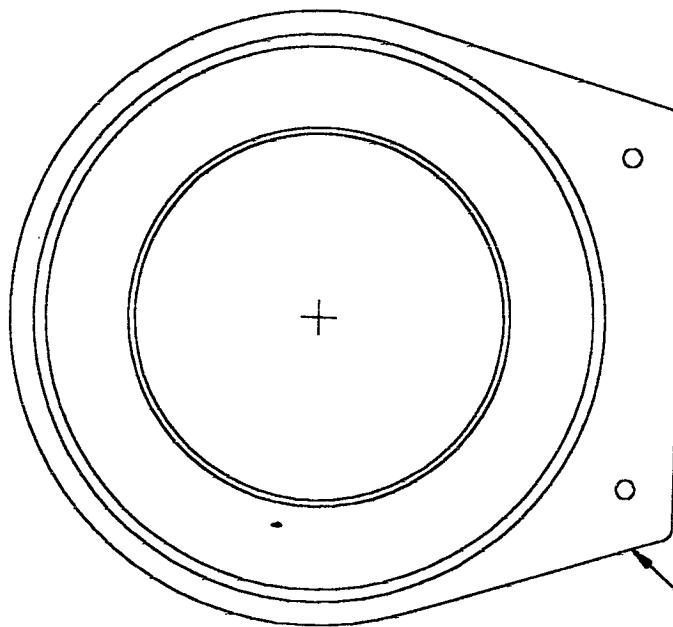
PREPARED	B. Williams	
CHECKED	BW	APPROVED
DATE	Jan. 10, 1995	

DART AERO ACCESSORIES INC  
VICTORIA INTERNATIONAL AIRPORT, CANADA  
REV. B  
SHEET 2 OF 2  
SCALE

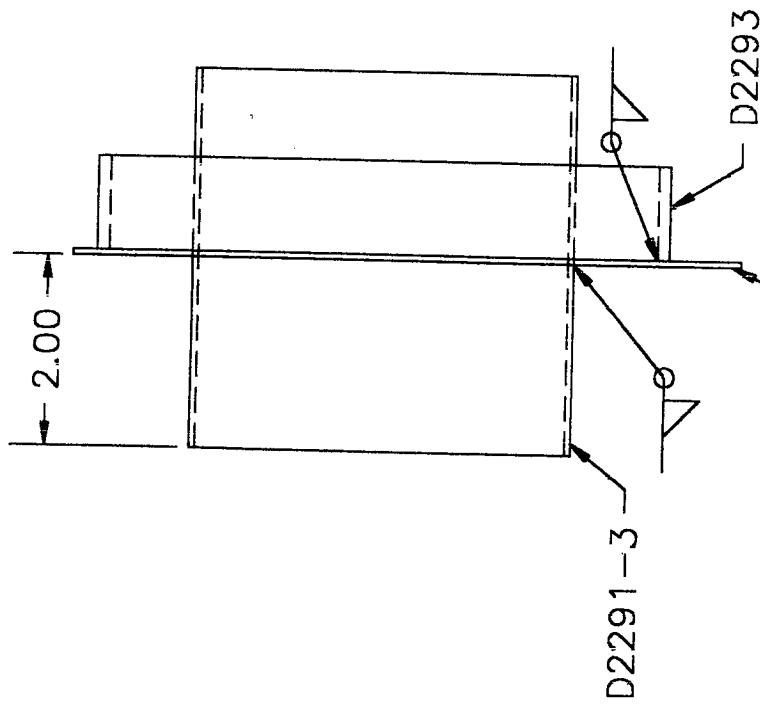
D2319

TITLE

OUTLET WELDMENT ASSEMBLY



D2288



D2288

D2293

D2291-3

